

Work Order ID 136794

September 09, 2015 11:43:51 AM

136794

Page 1

Shipping Sept 30

Item ID: D205-803-223

Accept

N1900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Left Hand Pilot in Command - Medium/Standard Design, Mechanical 205

Start Date: 9/9/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: 54 Date: 20150909

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D212-803	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D205-803-223 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

MW 15-09-09

DAS
02
9-89

SEP 30 2015

DAS
27
9-89

SEP 09 2015

DAS
02
9-89

DAS
02
9-89

SEP 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Work Order ID 136794***136794***

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Item ID: D205-803-223

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Left Hand Pilot in Command - Medium/Standard Design, Mechanical 205

Start Date: 9/9/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/23/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									DAS 02
Packaging	Memo	0.00							9-89
Packaging	Identify and pack for shipping as per PPP D205-803-223								SEP 30 2015
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							MLS SEP 30 2015
Quality Control									

20150930
Stu

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 136794

136794

Parent Item: D205-803-223

D205-803-223

Parent Item Name: Left Hand Pilot in Command - Medium/Standard Design, Mechanical 205

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.07.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5155-047		Manufactured	No				Each	0.0000		1			
D5155-047	DAS 02 9-89							B13679S**		1			
Co-Pilot Collective Head Assembly (205)													
D5156-1		Manufactured	No				Each	0.0000		1			
D5156-1	DAS 02 9-89							B13679K**		1		DAS 27 9-89	
Face Plate													
D5156-3		Manufactured	No				Each	0.0000		1			
D5156-3	DAS 02 9-89							B13679**		1		DAS 27 9-89	
Face Plate													
MS24693-24B		Purchased	No				Each	90.0000		4			
MS24693-24B	DAS 02 9-89								**			DAS 27 9-89	
Screw													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			90						
				m132256			90						
D4410-9		Manufactured	No				Each	6.0000		1			
D4410-9	DAS 02 9-89								**			DAS 27 9-89	
Trigger													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST103			6						
				116420			6						
D5055-1		Manufactured	No				Each	8.0000		1			
D5055-1	DAS 02 9-89								**			DAS 27 9-89	
Placard													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST144			8						
				117708			8						

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Work Order ID: 136794

136794

Parent Item: D205-803-223

D205-803-223

Parent Item Name: Left Hand Pilot in Command - Medium/Standard Design, Mechanical 205

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

D5055-3 Manufactured No

Each 14.0000 1

D5055-3

DAS
02
9-89

**

DAS
27
9-89

Placard

Location

Loc Qty

Loc Code

ST144

2

117709

2

ST155a

12

119593

12

AN565F8H9

DAS
02
9-89

Purchased

No

Each 31.0000 1

AN565F8H9

**

DAS
27
9-89

Set Screw

Location

Loc Qty

Loc Code

ST330

31

m129036

31

MS20253-1-065

MS20253-1-7200

Purchased

No

Each 8.0000 1

MS20253-1-065

**

DAS
27
9-89

Hinge Pin

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

8

123522

8

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Work Order ID: 136794

136794

Parent Item: D205-803-223

D205-803-223

Parent Item Name: Left Hand Pilot in Command - Medium/Standard Design, Mechanical 205

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

Each

796.0000

1

MS21042L08

Nut

DAS
02
9-89

**

27
9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

12

~~m131697~~

12

ST304

683

123900

16

m128401

102

m128429

3

m131317

62

m132930

500

MS21042L3

Purchased

No

Each

728.0000

1

MS21042L3

Nut

DAS
02
9-89

**

27
9-89

Location

Loc Qty

Loc Code

FP001

370

M130922

370

GA

220

M131317

220

ST305

138

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

17

M132930

39

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Work Order ID: 136794

136794

Parent Item: D205-803-223

D205-803-223

Parent Item Name: Left Hand Pilot in Command - Medium/Standard Design, Mechanical 205

Start Date: 9/9/2015

Required Date: 9/23/2015

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-07

Purchased

No

Each

475.0000

1

MS27039-1-07

DAS
02

**

DAS
27

9-89

Screw

9-89

Location

Loc Qty

Loc Code

GA

334

125654

334

ST286

141

m127813

133

m130388

8

MS24665-289

Purchased

No

Each

114.0000

2

MS24665-289

DAS

**

DAS
27

9-89

Cotter Pin

02

9-89

Location

Loc Qty

Loc Code

ST293

114

m128973

89

m128995

25

SEP 09 2015

7.. PARTS LIST - MEDIUM COLLECTIVE HEAD KITS

Qty -211	Qty -213	Qty -215	Qty -217	Qty -219	Qty -221	Qty -223	Part Number	Description
X							D205-803-211	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
	X						D205-803-213	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
		X					D212-803-215	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
			X				D212-803-217	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
				X			D212-803-219	LEFT HAND PILOT IN COMMAND, EAGLE SINGLE
					X		D205-803-221	LEFT HAND PILOT IN COMMAND, COMPLETE KIT
						X	D205-803-223	LEFT HAND PILOT IN COMMAND, MECHANICAL ONLY
1	1						D5155-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
		1	1				D5155-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
				1			D5155-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
					1	1	D5155-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205 WITH THE 204-001-290-5 STICK AND THROTTLE ASSY INSTALLED)
1	1			1	1	1	D5156-1	FACE PLATE
1	1			1	1	1	D5156-3	FACE PLATE
		1	1				D5156-5	FACE PLATE
		1	1				D5156-7	FACE PLATE
1	1			1	1	1	D4410-9	TRIGGER
1	1			1	1	1	D5055-1	PLACARD
1	1	1	1	1	1	1	D5055-3	PLACARD
		1	1				D5055-5	PLACARD
		1	1				D5055-7	PLACARD
		1	1				D5055-9	PLACARD
1	1	1	1	1			D4411-7	PLACARD
		1					27ET51-T	SWITCH (ALT P/N 212-075-153-3)
1					1		2PB744-T2	SWITCH
		3					30-037-26	DIODE ASSEMBLY
		2					30-037-3	DIODE ASSEMBLY
1	1			1	1	1	AN565F8H9	SETSCREW
		3					AN961-6T	WASHER
		1					51MX-5-J	SWITCH
1					1		C100E2-39	SWITCH
17		AR (21)			17		M39029/31-240	PIN
17		AR (21)			17		M39029/32-259	SOCKET
		AR (2)					M39029/31-228	PIN
		AR (2)					M39029/32-247	SOCKET
1	1			1	1	1	MS20253-1-065	PIN
		3					MS21042L06	NUT
1	1			1	1	1	MS21042L08	NUT
1	1	1	1	1	1	1	MS21042L3	NUT
		2					MS21044N04	NUT
1	1	1	1	1			MS21919WDG10	CLAMP
		1	1	1			MS21919WDG19	CLAMP
1	1						MS21919WDG20	CLAMP
		1					MS24523-27	SWITCH
		2					MS24693-S7	SCREW
4	4	4	4	4	4	4	MS24693-24B	SCREW
1	1	1	1	1	1	1	MS27039-1-07	SCREW
		1					MS27212-1-3	TERMINAL BOARD
1					1		MS3126E14-19P	PLUG
1					1		MS3120E14-19S	SOCKET
		2					MS3126E16-99P	PLUG
		1					MS3120E16-99S	SOCKET
		3					MS3373-A1	STRIP
2	2	2	2	2			NAS1149D0363J	WASHER
					2	2	MS24665-289	COTTER PIN
1	1	1	1	1	1	1	D212-803	KIT PAPERWORK

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